



120 QC 4	1 pcs	9/13/19	0.00 0.00	Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
130 Packaging 3-1 - Stock - B4B	1 pcs	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	9/13/19	0.00 0.00	DC - 1 - B4B	SEP 23 2019
				DC - 2 - B4B	
140 QC 21 - FG	1 pcs	9/13/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Max B. 9/23/2019

HL

SEP 23 2019

SEP 23 2019

DAS
70
9-89

Part Op 110 - Packaging1-4 (Pick Kit)
 Descriptions: 120 - QC4 (QC4- 100% Inspect kits for completeness)
 130 - Packaging3-2 (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D412-742-

023 Location :FG083

135 - DC (Document Control) Photocopy blue file and create labels per PPP D412-742-023 CHG002

140 - QC21 (QC21- Final Inspection - Work Order Release) NULL

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C46A	Bolt	13 Ea (13 ea)	110-Packaging 1 - Pick Kit	5176429
AN4C47A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5201354
AN4C52A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5201296
AN4C6A	Bolt	16 Ea (16 ea)	110-Packaging 1 - Pick Kit	5174255
AN4C7A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5190028
AN6C12A	Bolt	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5143192
D2747	Set Screw	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5150679
D2875	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5178520
D2877	Saddle Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5178522
D3405-041	Ground Handling Lug	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5186591
D3405-043	Ground Handling Lug	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5206454
D3407-047	Tow Ring	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5196344
D3455-1	Washer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5199355
D3533-1	Set Screw	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5157291
D3672-3	Washer, Phenolic	32 pcs (32 ea)	110-Packaging 1 - Pick Kit	5175816
D3672-9	Washer	8 pcs (8 ea)	110-Packaging 1 - Pick Kit	5153355
D5446-1	Bushing	24 pcs (24 ea)	110-Packaging 1 - Pick Kit	5190408
D5466-1	Saddle, Fwd, In	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5180407
D5467-1	Saddle, Fwd, Out	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5180408
D5468-1	Saddle, Aft, Out	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5191204
D5469-1	Saddle, Aft, In	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5181760
D5482-1	Washer	8 pcs (8 ea)	110-Packaging 1 - Pick Kit	5144362
D5482-3	Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5178013
D5513-1	Bushing	6 pcs (6 ea)	110-Packaging 1 - Pick Kit	5196480
MS21043-3	Nut	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5176493
MS21043-4	Nut	28 Ea (28 ea)	110-Packaging 1 - Pick Kit	5198136
NAS1149C0332R Washer (AN960C16L)		75 Ea (75 ea)	110-Packaging 1 - Pick Kit	5193136
NAS1149C0432R Washer (AN960C16L)		32 Ea (32 ea)	110-Packaging 1 - Pick Kit	5181723
NAS1149C0502R Washer (AN960C16L)		8 pcs (8 ea)	110-Packaging 1 - Pick Kit	5176870
AN4C53A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5140478
D412-742-053	Repl. Skidtube, DART (Apical) Tri-Bag Float Compatible - Fits LH or RH	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5213816

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3C46A	13	157	0
	AN4C47A	4	90	0
	AN4C52A	4	106	0
	AN4C53A	4	57	0
	AN4C6A	16	362	0
	AN4C7A	4	103	0
	AN6C12A	8	101	0
	D2747	4	140	0
	D2876	2	37	0
	D2877	2	36	0
	D3405-041	1	4	0
	D3405-043	1	2	0
	D3407-047	1	8	0
	D3456-1	1	185	0
	D3533-1	2	105	0
	D3672-3	32	10,416	0
	D3672-9	8	505	0
	D412-742-053	1	0	0
	D5446-1	24	159	0
	D5466-1	1	5	0
	D5467-1	1	6	0
	D5468-1	1	6	0
	D5469-1	1	6	0
	D5482-1	8	52	0
	D5482-3	2	58	0
	D5513-1	6	296	0
	MS21043-3	3	764	0
	MS21043-4	28	956	0
	NAS1149C0332R	75	3,684	0
	NAS1149C0432R	32	1,417	0
	NAS1149C0632R	8	515	0
Part Specifications				
Specifications could not be found.				

Plex 7/31/19 8:04 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



DISPOSITION		DEPARTMENT/PROCESS																																																	
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	MRB (QSI042)					Completed By																																								
Date: _____	Sequence #: _____	QTY Affected: _____										Lead hand / Supervisor																																							
Description Work Order Deviation												QC / QA Coordinator																																							
Root Cause												FAULT CATEGORY																																							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐												Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____										Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐										Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐										Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐									

5.2 D412-742-023 (DART TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -023	Qty -053	Part Number	Description
	X		D412-742-023	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-053	FLOAT SKIDTUBE
		1	D412-742-055	WEARPLATE KIT
		1	D5425-043	FLOAT SKIDTUBE ASSY.
1		*6	*D3672-1	*WASHER
2		30	D5513-1	BUSHING
3		*12	*D5512-1	*CROSSBOLT SPACER
5		*1	*D5525-3	*FLOAT SKIDTUBE
6		*1	*D5483-041	*TOW CAP ASSY.
7		*1	*D5484-041	*AFT CAP ASSY.
12		*18	*D5518-1	*CROSSBOLT SPACER
13		*6	*AN3C5A	*BOLT
14		15	AN3C44A	BOLT
15		*6	*NAS1149C0332R	*WASHER
16		15	MS21043L3	NUT
30	1		D5466-1	SADDLE, FWD INSIDE
31	1		D5467-1	SADDLE, FWD OUTSIDE
32	1		D5468-1	SADDLE, AFT OUTSIDE
33	1		D5469-1	SADDLE, AFT INSIDE
34	16		AN4C6A	BOLT
35	28		MS21043-4	NUT
36	32		NAS1149C0432R	WASHER
37	32		D3672-3	PHENOLIC WASHER
38	8		AN4C52A	BOLT
39	24		D5446-1	BUSHING
40	8		AN6C12A	BOLT
41	8		NAS1149C0632R	WASHER
42	8		D3672-9	WASHER
43	2		D2876	SADDLE SPACER
44	2		D2877	SADDLE SPACER
45	4		D2747	SET SCREW
46	2		D3533-1	SET SCREW
47	4		AN4C7A	BOLT
50	1		D3407-047	TOW RING
51	2		D5482-3	ACETAL WASHER
52	1		D3456-1	WASHER
60	1		D3405-041	GHW LUG
61	1		D3405-043	GHW LUG
62	4		AN4C47A	BOLT
63	8		D5482-1	ACETAL WASHER
71	75**		NAS1149C0332R	WASHER
72	6		D5513-1	BUSHING
73	3		MS21043-3	NUT
74	13		AN3C46A	BOLT

*DENOTES PART IS INCLUDED WITH D5425-043 ASSEMBLY

**INCLUDES ADDITIONAL WASHERS TO COMPENSATE FOR VARIANCE IN STACKUP THICKNESS

4.0 WEIGHT AND BALANCE

When the DSI 9800-011 Wearplate Replacement Kit has been installed, the updated Weight and Balance for the D412-742-021/-023 Float Skidtubes is as follows:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-742-021	73.4 lb	+/- 55 in	+/- 4037 in-lb	124 in	9102 in-lb
FLOAT SKIDTUBE INSTALLATION @ CHG 002	33.3 kg	+/- 1.4 in	+/- 46.5 m-kG	3.15 m	105 m-kG
D412-742-023	72.0 lb	+/- 55 in	+/- 3960 in-lb	124 in	8928 in-lb
FLOAT SKIDTUBE INSTALLATION @ CHG 002	32.7 kg	+/- 1.4 m	+/- 45.6 m-kG	3.15 m	103 m-kG

5.0 PARTS LIST

Qty -011	Part Number	Description
X	DSI 9800-011	REPLACEMENT WEARPLATE KIT
1	D5489-041	FWD WEARPLATE ASSEMBLY
1	D5489-3	MD WEARPLATE
1	D5489-045	AFT WEARPLATE ASSEMBLY
4	AN4C53A	BOLT
13	AN3C44A	BOLT
10	AN3C46A	BOLT
20	NAS1149C0332R	WASHER
4	MS21043-4	NUT
13	MS21043-3	NUT

Update the Parts List in IIN-D412-742-2 Rev A and ICA-D412-742-2 Rev 0 as follows.

Item	Qty -021	Qty -051	Qty -055	Part Number	Description
	X			D412-742-021	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-051	FLOAT SKIDTUBE
		1	X	D412-742-055	WEARPLATE KIT
38	8			AN4C52A	BOLT
38a	4			AN4C52A	BOLT
38b	4			AN4C53A	BOLT

← DELETE
← ADD
← ADD

Item	Qty -023	Qty -053	Part Number	Description
	X		D412-742-023	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-053	FLOAT SKIDTUBE
		1	D412-742-055	WEARPLATE KIT
38	8		AN4C52A	BOLT
38a	4		AN4C52A	BOLT
38b	4		AN4C53A	BOLT

← DELETE
← ADD
← ADD

APPROVED

DESIGN	MW	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	MW		
CHECKED	NO	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9800	SHEET 5 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	WEARPLATE REPLACEMENT	NTS
DATE	18.05.17	COPYRIGHT © 2018 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D412-742-023

Description: FLOAT SKIDTUBE INSTALLATION (DART TRI-BAG)

[illegible]